



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3137-043
Job Sheet 175490



Part No: D3137-043

Job Qty: 6 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/5/18

Job Tracking No:

Due Date: 5/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F IPP Rev:A 04.02.18 New issue KJ/DS IPP Rev B 08.07.03 ECN1207 EC verified by DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	5/4/18	5/4/18	0.00	0.00	Start Up Machining-1		18-05-06
100	Bandsaw	6 pcs	5/4/18	5/4/18	0.00	0.14	Bandsaw1		18-05-06
110	CNC Vertical Machining	6 pcs	5/5/18	5/5/18	0.16	11.11	HAAS1-3		18-05-06
120	QC	6 pcs	5/5/18	5/5/18	0.00	0.00	QC2 Machining-1		18-05-06
130	QC	6 pcs	5/5/18	5/5/18	0.00	0.00	QC8 Machining-1		18-05-07
140	Small Fab	6 pcs	5/7/18	5/7/18	0.00	0.33	Small Fab-2		DAS
150	QC	6 pcs	5/7/18	5/7/18	0.00	0.00	QC5		38
160	Packaging	6 pcs	5/7/18	5/7/18	0.00	0.00	Packaging3-1		MAY 09 2018
170	QC21-SA	6 Ea	5/7/18	5/7/18	0.00	0.00	QC21		DAS

Part Op 100 - Cut blanks: (.500" x 2.000") 5.570" long

Descriptions: 110 - 1-Machine D3137-7 as per Folio FA3308 and Dwg D3137 Identify as D3137-7

140 - Assemble D3137-043 as per Dwg D3137

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MS24694-S101	Screw	6 Ea (1 ea)	90-Start up Operation	FM129909
D3137-3	Guide	6 Ea (1 ea)	140-Small Fab	5053593
D3137-5	Washer	6 Ea (1 ea)	140-Small Fab	F150220
M17-4-B0.500X2.000	17-4 SS Bar .500 x 2.00	2.7858 ft (.4643 ea)	140-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MS24694-S101	6	32	0
140-Small Fab	D3137-3	6	16	0
	D3137-5	6	31	0
	M17-4-B0.500X2.000	3	2	0

Part Specifications

Specifications could not be found.

Plex 4/5/18 2:41 PM Dart.lajeunesse.marie

M174B0.500X02.000
M135545

M135545
inl.

DOA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
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Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step # : _____	LOT# _____		MRB (QSI042) Approval																	
16111 HURONTARIO AVENUE NEWKENSINGTON, ON K6A 1K7 CANADA TEL: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 05/06/18 Container No: S068722 Part: D3137 - 043 Job No: 175490 Serial No/Batch: S068722 Revision: _____ Inspector: _____																					

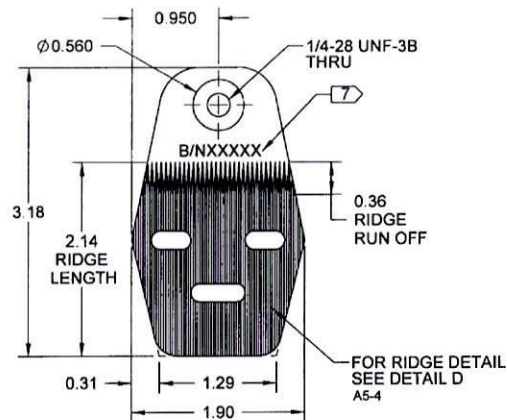
DART AEROSPACE LTD		Work Order:	
Description: Bracket		Part Number:	D3137-7
Inspection Dwg: D3137 Rev: F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

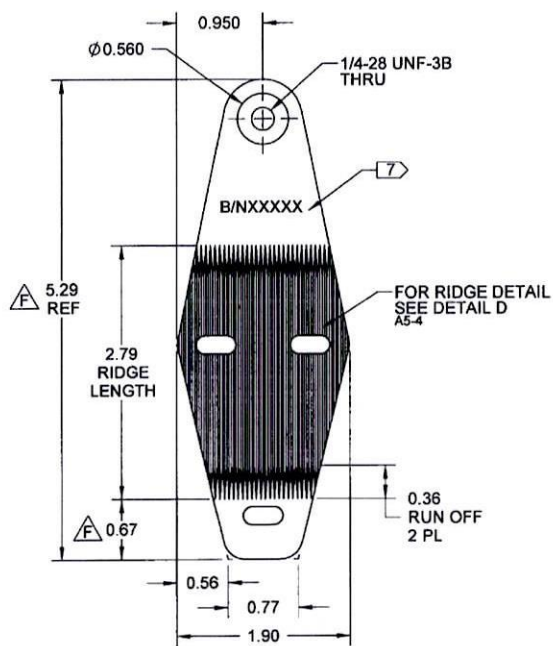
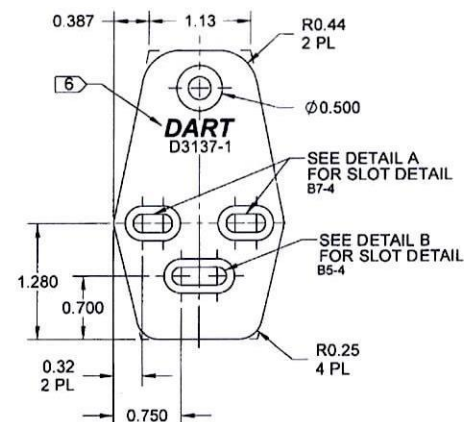
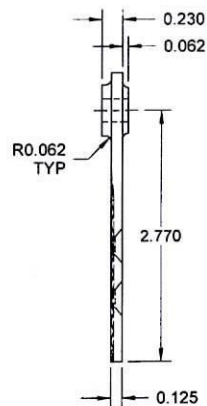
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.560	+0.006/-0.001	0.560	✓		K+-05	Verif.
5.29	+/-0.030	5.290	✓		" "	" "
2.79	+/-0.030	2.790	✓		" "	" "
0.67	+/-0.030	0.683	✓		" "	" "
1.90	+/-0.030	1.890	✓		" "	" "
0.262	+/-0.010					
0.062	+/-0.010	0.062	✓		K+-05	Verif.
4.850	+/-0.010	4.852	✓		" "	" "
0.162	+/-0.010	0.162	✓		" "	" "
Ø0.500	+0.006/-0.001	0.500	✓		" "	" "
2.360	+/-0.010	2.362	✓		" "	" "
1.880	+/-0.010	1.880	✓		" "	" "
0.480	+/-0.010	0.481	✓		" "	" "

Measured by: <u>DAS</u>	Audited by: <u>S.J.</u>	Preliminary Approval:	N/A
Date: <u>2018/05/06</u>	Date: <u>18-05-07</u>	Date:	N/A

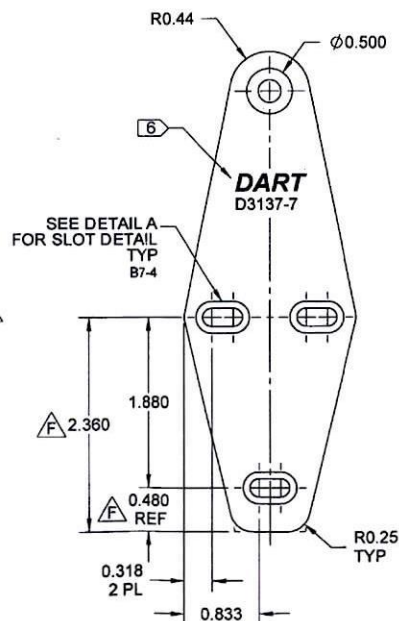
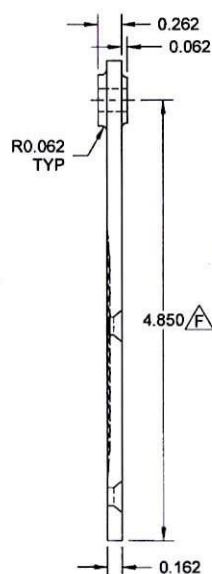
Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3137-043	KJ/RF	
B	04.06.15	Changed & added dimensions	KJ/JLM	
C	06.03.15	Dwg Rev updated	KJ/JLM	
D	08.12.02	Dwg Rev updated	KJ/DD	
E	10.08.03	Dimension 5.29 was 0.529	KJ	



D3137-1 BRACKET



D3137-7 BRACKET



NOTES:

- 1) MATERIAL: -1 & -7
17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) -1 REPLACES PREMIER P/N B30-23000-105/-06

RELEASED
08-05-30

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
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